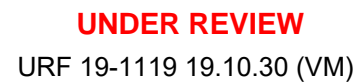


UNDER REVIEW

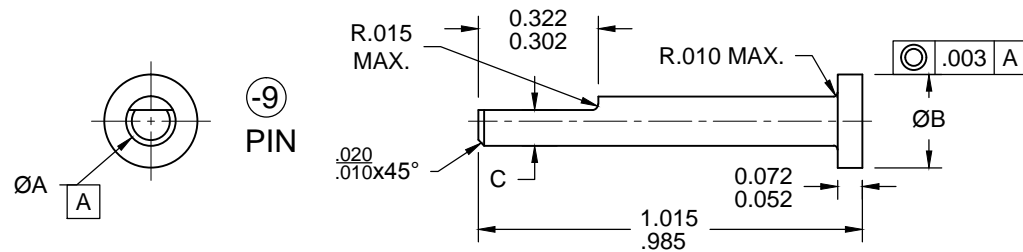
URF 19-1119 19.10.30 (VM)

BEARING #	TOOL #	ØA +.000 -.002	TYPE	MATERIAL
--	RCST4104-3HOB	.185	I	1018 RND. BAR

RED BARN MACHINE	
TITLE LOCATING PIN	
DWG NO. RCST4104-3HOB-15	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	
DECIMALS	FRACTIONS ± 1/32
.XXX ± .005	ANGLES ± 5°
.XX ± .01	
.X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 12-20-07
SHEET 9 of 9	



BEARING #	TOOL #	ØA +.000 -.020	ØB +.000 -.005	MATERIAL		TITLE	
--	RCST4104-3HOB	1.062	.468	4140 Q&T	RND. BAR	PRIMARY	
						DWG NO.	RCST4104-3HOB-11
						REV	
						UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
						TOLERANCES ON: DECIMALS	
						.XXX ± .005 FRACTIONS ± 1/32	
						.XX ± .01 ANGLES ± 5°	
						X ± 1	
						UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R	
						2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
						DRAWN BY: PERRITT	
						APPROVED	
						HEAT TREAT	
						FINISH BLACK OXIDE	
						USED ON MODEL	
						SCALE NTS	
						DATE 12-20-07	
						SHEET 7 of 9	

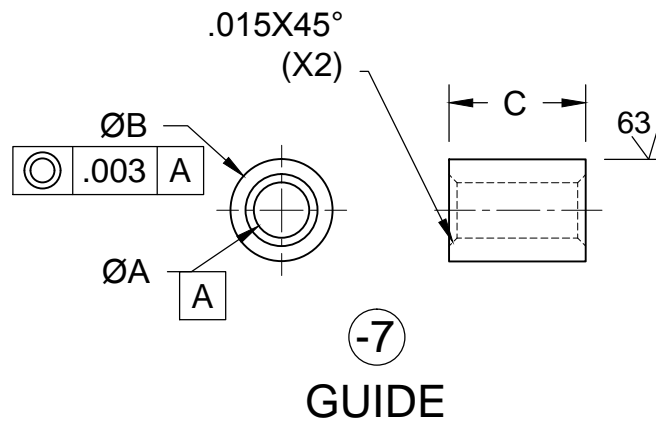


UNDER REVIEW

URF 19-1119 19.10.30 (VM)

BEARING #	TOOL #	ØA +.000 -.005	ØB +.005 -.005	ØC +.000 -.020	MATERIAL
--	RCST4104-3HOB	.099	.180	.074	1018 RND. BAR


RED BARN MACHINE	
TITLE PIN	
DWG NO. RCST4104-3HOB-9	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5° .X ± .1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 12-20-07
SHEET 6 of 9	

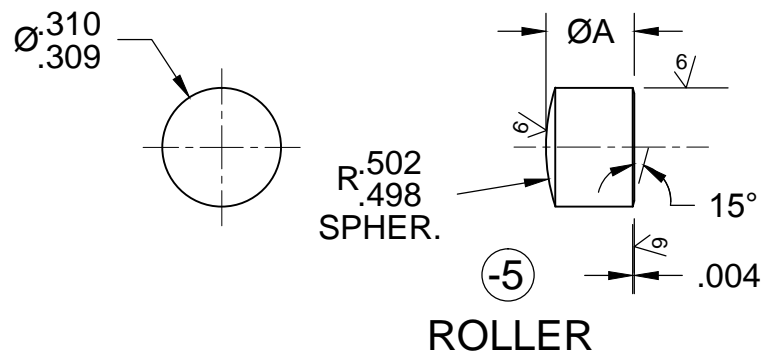


UNDER REVIEW

URF 19-1119 19.10.30 (VM)

BEARING #	TOOL #	ØA +.001 -.001	ØB +.000 -.002	ØC +.000 -.010	MATERIAL
--	RCST4104-3HOB	.101	.186	.250	BRONZE


 RED BARN MACHINE	
TITLE GUIDE	
DWG NO. RCST4104-3HOB-7	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE NTS	DATE 12-20-07 SHEET 5 of 9

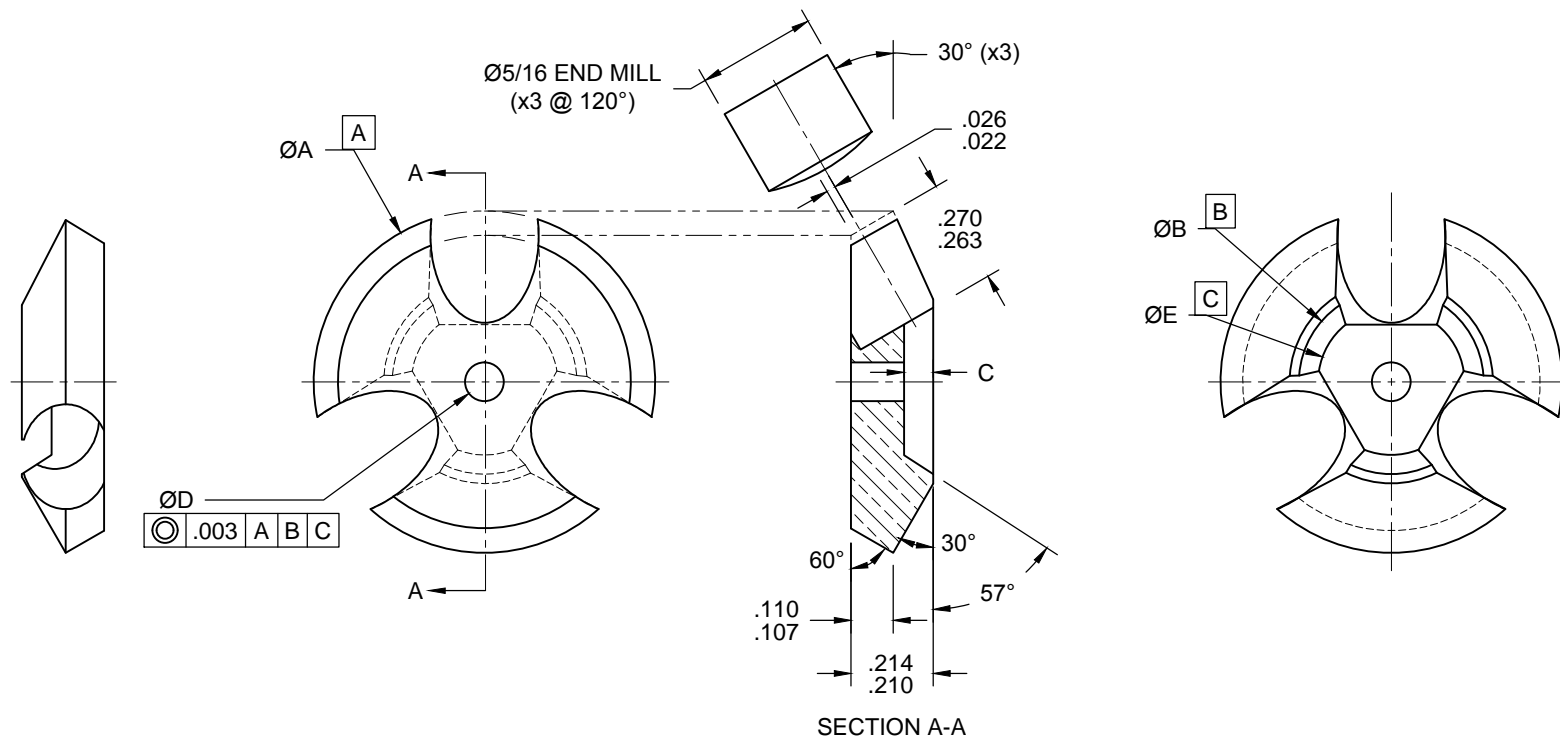


UNDER REVIEW

URF 19-1119 19.10.30 (VM)

BEARING #	TOOL #	ØA +.001 -.000	MATERIAL
--	RCST4104-3HOB	.255	0-1 DRILL ROD

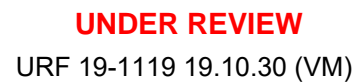
 RED BARN MACHINE	
TITLE ROLLER	
DWG NO. RCST4104-3HOB-5	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1	DRAWN BY: PERRITT APPROVED HEAT TREAT RC 55-60 FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL
SCALE NTS	DATE 12-20-07 SHEET 4 of 9




UNDER REVIEW

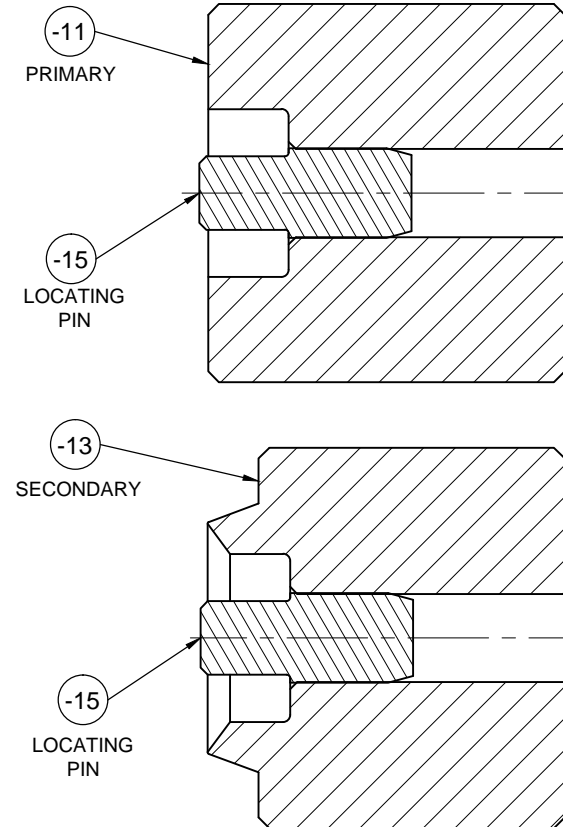
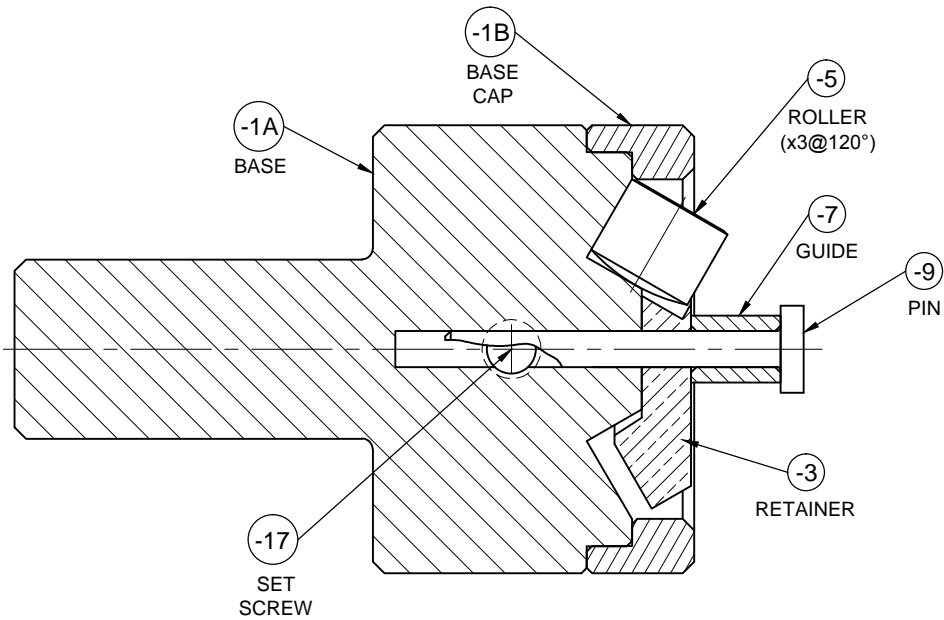
URF 19-1119 19.10.30 (VM)

BEARING #		TOOL #	ØA +0.002 -0.002	ØB +0.005 -0.000	ØC +0.010 -0.000	ØD +0.004 -0.001	ØE +0.005 -0.000	MATERIAL
--		RCST4104-3HOB	.890	.481	.076	.101	.381	BRONZE
					</			



		-1A BASE							-1B CAP				 RED BARN MACHINE		
BEARING #	TOOL #	ØA + .000 - .010	ØB + .002 - .000	ØC + .002 - .000	ØD P.D. REF.	ØE + .002 - .000	ØF + .0000 - .0004	ØG + .000 - .001	MATERIAL	ØH + .000 - .010	ØI + .002 - .000	ØJ + .0004 - .0000	MATERIAL	TITLE BASE & CAP	
--	RCST4104-3HOB	1.250	.950	.513	.638	.336	1.100	.101	0-1 DRILL ROD	1.250	.948	1.099	1018 RND. BAR	DWG NO. RCST4104-3HOB-1 REV	
														UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
														TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1	
														FRACTIONS ± 1/32 ANGLES ± 5°	
														UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
														DRAWN BY: PERRITT APPROVED HEAT TREAT RC 55-60 FINISH BLACK OXIDE USED ON MODEL	
														SCALE NTS DATE 12-20-07 SHEET 2 of 9	

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
—	—	—	—	—



NOTES

1. -1 RACE SURFACE MUST HAVE SMOOTH APPEARANCE FREE FORM MACHINING MARKS AND GROOVES.
2. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
3. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
4. FLAT END OF ROLLERS MUST FACE AWAY FROM CENTER OF THE TOOL WHEN ASSEMBLED.

UNDER REVIEW

URF 19-1119 19.10.30 (VM)

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	BASE	O-1	SEE CHART	2
		-3	1	RETAINER	BRASS	SEE CHART	3
		-5	3	ROLLER	O-1	SEE CHART	4
		-7	1	GUIDE	BRASS	SEE CHART	5
		-9	1	PIN	1018	SEE CHART	6
		-11	1	PRIMARY	4140 Q&T	SEE CHART	7
		-13	1	SECONDARY	4140 Q&T	SEE CHART	8
		-15	2	LOCATING PIN	1018	SEE CHART	9
	B/O	-17	1	SOCKET HEAD SET SCREW	PLAIN	#8-32 x 1/4	N/S

RED BARN MACHINE

TITLE		TRI-ROLLER SWAGING TOOL; ASSY.	
DWG NO.	RCST4104-3HOB	REV	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS		HEAT TREAT -1&-5; RC 55-60	
.XXX ± .005		FINISH LISTED PER ITEM	
.XX ± .01		USED ON MODEL	
X ± .1			
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	NTS	DATE	12-20-07
		SHEET	1 of 9

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
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URF 19-1119 19.10.30 (VM)

 RED BARN MA

UNDER REVIEW

URF 19-1119 19.10.30 (VM)

ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MAT.	B/O INFORMATION OR SPECIFICATIONS	Pg.	TITLE
	-1	1	RND	6061	Ø8-1/4 x 3-7/8	2	DWG NO.	REV
							UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	DRAWN BY: PERRITT
							TOLERANCES ON:	APPROVED
							DECIMALS	HEAT TREAT
							.XXX ± .005	FINISH SPEC
							.XX ± .01	FRACTIONS ± 1/32
							X ± .1	ANGLES ± 5°
							UNLESS OTHERWISE SPECIFIED	USED ON MODEL
							1. BREAK ALL SHARP EDGES	
							.015 x 45° PR .015 R	
							2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
ASSY #							SCALE NTS	DATE 8-15-07 SHEET 1 of 1

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